

# Work Order ID 83242

**\*83242\***

Page 1

April-16-12 11:06:51 AM

Item ID: D350-636-013

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 16/04/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/04/16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2750	F
D3492	C
IIN-D350-636	I

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-013 CHG 006

① MLJ 12-05-10  
for MLJ 12-5-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83242

**\*83242\***

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Item ID: D350-636-013 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube LH  
 Start Date: 16/04/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 30/04/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
<b>*110*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-3 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***								
	8- Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)								
	9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	10- Open up holes of Detail A to 0.297" (total of 2 holes per side)								

*gt 12-04-24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Item ID: D350-636-013

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 16/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: <u>M120854</u> <i>BE 12/04/24</i>								
	12-Grind welds flush as per Dwg D2750 <i>12-04-24</i>								
120 <b>*120*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00 0.00							
130 <b>*130*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83242

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Item ID: D350-636-013

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 16/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
150	<del>QC3</del> Inspect Part Finish	0.00							
<b>*150*</b>	QC7								
QC	Memo	0.00							
Quality Control									

746 12425

8/2/12

Ⓢ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 83242****\*83242\***

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Item ID: D350-636-013

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 16/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00

**\*160\***

Skidtubes

Skidtubes

Skidtubes

**Memo**

0.00

1-Open up holes section AW-AW 0.500" (4 per side) as per dwg D2750

3-Open up holes of Detail T and ground handling to 0.625" (total of 8 holes per side Detail AV-AV) as per dwg D2750.

4-Chamfer holes of section AW-AW, AV-AV, T and ground handling. (welding instructions on sheet 10)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding. remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: M121221  
exp. date: 13-1-4

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 10)

A/R Aluminum Rod batch: M130854BE 12-05-02

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

CF 12-5-1

SP/CC 12-5-3

W/O: 83242		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D39-636-03 PAR #: \_\_\_\_\_ Fault Category: LANDING GEAR / SKID NCR: Yes No QA 12/05/28  
12/14/25 Resolution: Rework Disposition: Rework QA: N/C Closed Date: 12/5/28

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/26	#160	When open up holes operator didn't pay attention to his drawing and opened up holes #19 & 20 from AH to 0.630". Should be @ 500".	CP 12.04.27 PS1042	- INSTALL CUSTOM $\phi 0.630$ OP. X $\phi 0.42$ 10. X-BOLT SPACERS. 6061-T6 ALUMINUM BIN 120603 - Acceptable - REF D3490 DWG ATTACHED	CF 12-5-1 SE 12-05-01	17/05/28	CP 12.04.27 PS1042	S 12/04/26
		Re 10A		Qty (2)				S 12/04/26

NOTE: Date & initial all entries

# Work Order ID 83242

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Item ID: D350-636-013

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 16/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC10- Inspect visual per QSI004- ground welds	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									
190	Pressure Wash per QSI005 4.3	0.00							
<b>*190*</b>									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								

1 & 2P 12/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83242

\*83242\*

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April-16-12 11:06:51 AM

Item ID: D350-636-013

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube LH

Stop \*NS2\*

Start Date: 16/04/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
*200*									
Powdercoat									
Powder Coating									
	Memo								
	START TIME: 2:40	0.00							
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 3:10								
210	QC3- Inspect Part Finish	0.00							
*210*									
QC									
Quality Control									
	Memo								
	Inspect for foreign object per QSI 024								
220		0.00							
*220*	HandFinishing								
HandFinish									
Hand Finishing									
	Memo								
	1-Install inserts as per dwg D2750								

1X ✓ 12/05/07

1WH d 12/05/08

1R 12/05/07

LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Work Order ID 83242

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Item ID: D350-636-013

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 16/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
<b>*230*</b>	HandFinish	0.00							
Hand Finishing	Memo	0.00							
	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: <u>N/A</u>								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>121221</u> EXP DATE: <u>13/01</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>110348</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>114596</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
<b>*240*</b>	QC	0.00							
Quality Control	Memo	0.00							

1 8 22 12/05/08  
LH

Scrubbed

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID 83242

\*83242\*

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Item ID: D350-636-013

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube LH

Start Date: 16/04/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
<b>*250*</b>									
Packaging	Memo	0.00							12/15/10
Packaging									SP
260	QC4- 100% Inspect kits for completeness	0.00							
<b>*260*</b>									
QC	Memo	0.00							12/15/10
Quality Control									
270	Packaging	0.00							
<b>*270*</b>									
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-013								12-5-10

83242 LH

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Item ID: D350-636-013

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 16/04/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00

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Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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280

QC21- Final Inspection - Work Order Release

0.00

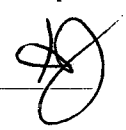
**\*280\***

QC

Memo

0.00

Quality Control

12/5/14   
MUF  
12-05-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 83242

\*83242\*

Parent Item: D350-636-013

\*D350-636-013\*

Parent Item Name: Skidtube LH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:H02.09.25Rearranged procedure steps KJ  
 IPP rev I 06.03.30 Per rev. D dwg EC  
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec IPP Rev:L  
 10.06.22 revise seq110 DD verf:EC IPP Rev:M 10.10.01 as  
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	23.0000	1	1			
*D2600-3-BFNT*					B83305				**	①		2012-04-23	
Extrusion Bent													

Location	Loc Qty	Loc Code
LG	23	
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
81330	4	
82347	8	

D3493-1

Manufactured No

110

Each

87.0000

2

\*D3493-1\*

Washer

\*\*

2  
12/5/10 SP

Location	Loc Qty	Loc Code
ST050	87	
70697	2	
77573	4	
78835	40	
82023	41	

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 83242

**\*83242\***

Parent Item: D350-636-013

**\*D350-636-013\***

Parent Item Name: Skidtube LH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

6.0000

1

1

**\*D2739\***

350 I Beam

\*\*

1

CF 12-5-1

Location

Loc Qty

Loc Code

LG

6

72155

1

81508

1

82123

2

82124

2

D2744

Manufactured No

160

Each

30.0000

1

1

**\*D2744\***

Cap

\*\*

BE 12/04/14

Location

Loc Qty

Loc Code

LG002

30

62715

1

70881

1

78900

28

D3490-1

Manufactured No

160

Each

64.0000

4

4

**\*D3490-1\***

Cross Bolt Spacer

\*\*

BE 12/05/02

B 83269 x2

Location

Loc Qty

Loc Code

LG

55

81976

55

LG001

9

62450

2

74875

4

77042

3

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 3

Work Order ID: 83242

**\*83242\***

Parent Item: D350-636-013

**\*D350-636-013\***

Parent Item Name: Skidtube LH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-5

Manufactured No

160

Each

29.0000

4

4

**\*D3490-5\***

Cross Bolt Spacer

\*\*

BE 12/05/02

Location

Loc Qty

Loc Code

LG

25

78958

25

LG001

4

59230

4

4

D2743

Manufactured No

220

Each

281.0000

8

8

**\*D2743\***

Crossbolt Spacer

\*\*

BE 12/05/02

Location

Loc Qty

Loc Code

LG

-3

81965

207

LG001

284

67766

4

68251

3

73403

64

74445

1

79517

2

8

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 83242

\*83242\*

Parent Item: D350-636-013

\*D350-636-013\*

Parent Item Name: Skidtube LH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

2,265.000

38

38

\*AI S4-1032-225\*

Insert

\*\*

38

28

12/05/08

## Location

## Loc Qty

## Loc Code

ST281

2242

108696

146

110768

62

118386

55

118966

68

120671

37

121269 ✓

1874

ST282

23

120410

10

120451

13

AN3C5A

Purchased

No

230

Each

1,456.000

34

34

\*AN3C5A\*

Bolt

\*\*

34

28

12/05/08

## Location

## Loc Qty

## Loc Code

FP001

7

115835

7

ST350

1449

116419

28

117343

13

117764

7

117872

2

119749

23

120423

376

1210168

500

121255

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 83242

\*83242\*

Parent Item: D350-636-013

\*D350-636-013\*

Parent Item Name: Skidtube LH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

481.0000

4

4

**\*AN3C6A\***

BOLT

\*\*

4 (2P) 12/05/08

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

480

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

3

120693 ✓

388

AN6C44A

Purchased

No

230

Each

154.0000

4

4

**\*AN6C44A\***

BOLT

\*\*

4 (2P) 12/05/08

Location

Loc Qty

Loc Code

FG

2

120563 ✓

103964

2

ST343

152

120143

25

120465

16

121013

11

121167 ✓

100

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 6

Work Order ID: 83242

\*83242\*

Parent Item: D350-636-013

\*D350-636-013\*

Parent Item Name: Skidtube LH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

99.0000

1

1

\*AN8C35A\*

BOLT

\*\*

1 DP 12/05/08

## Location

## Loc Qty

## Loc Code

FP002

98

115960

1

117834

2

118286 ✓

45

121275

50

ST346

1

114442

0

115188

0

115960

1

AN960C10L

~~X~~ NAS1149C0332  
R

Purchased

No

230

Each

0.0000

38

38

\*AN960C10I \*

washer

D2745

Manufactured

No

230

Each

8.0000

8

8

\*D2745\*

Bushing

\*\*

38 DP 12/05/08

\*\*

8 DP 12/05/08

## Location

## Loc Qty

## Loc Code

FP

6

79518

6

FP001

2

69529

1

76142

1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Work Order ID: 83242

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

\*83242\*

\*D350-636-013\*

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230

Each

8.0000

1

1

\*D3488-041\*

Blade Fitting Assembly, LH

\*\*

1

(2P)

12/05/08

Location

Loc Qty

Loc Code

FP002

82271 ✓

8

61689

1

75056

1

77021

6

D3492-1

Manufactured No

230

Each

101.0000

8

8

\*D3492-1\*

Plug

\*\*

8

(2P)

12/05/08

Location

Loc Qty

Loc Code

FP002

83098 ✓

14

69531

8

74444

2

76235

4

FP-A

87

81963

87

D3492-5

Manufactured No

230

Each

72.0000

8

8

\*D3492-5\*

Plug

\*\*

8

(2P)

12/05/08

Location

Loc Qty

Loc Code

FP

40

78792 ✓

40

FP002

32

77044

32

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 83242

\*83242\*

Parent Item: D350-636-013

\*D350-636-013\*

Parent Item Name: Skidtube LH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

35.0000

1

1

\*D3535-25\*

Wearshoe

\*\*

1 12/05/08

## Location

## Loc Qty

## Loc Code

FP001

35

62233

1

80331

6

81357

11

82156 ✓

17

D3536-25

Manufactured No

230

Each

18.0000

1

1

\*D3536-25\*

Gasket

\*\*

1 12/05/08

## Location

## Loc Qty

## Loc Code

FP

14

81342

14

FP002

4

78902

4

D3537-1

Manufactured No

230

Each

21.0000

3

3

\*D3537-1\*

Wearpad

\*\*

3 12/05/08

## Location

## Loc Qty

## Loc Code

FG

10

79833

10

FP002

11

69817

5

80337

4

81361

2

81959 ✓  
81362 ✓

2

1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 83242

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

\*83242\*

\*D350-636-013\*

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3631-1

Manufactured No

230

Each

187.0000

8

8

\*D3631-1\*

Washer

\*\*

8

12/05/08

Location

Loc Qty

Loc Code

FG

83578

100

81874

100

ST072

87

68062

2

75548

85

D3791-1

Manufactured No

230

Each

21.0000

1

1

\*D3791-1\*

Wearplate

\*\*

1

12/05/08

Location

Loc Qty

Loc Code

FP002

83392

21

62239

2

78897

3

82168

16

D3793-1

Manufactured No

230

Each

21.0000

1

1

\*D3793-1\*

Wearshoe

\*\*

1

12/05/08

Location

Loc Qty

Loc Code

FP001

83393

21

78901

5

82171

16

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 83242

\*83242\*

Parent Item: D350-636-013

\*D350-636-013\*

Parent Item Name: Skidtube LH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

26.0000

1

1

\*D3793-3\*

Wearshoe

\*\*

1 (2P) 12/05/08

## Location

## Loc Qty

## Loc Code

FP001

23

80434

11

82166 ✓

12

FP002

3

78935

3

D3794-1

Manufactured No

230

Each

35.0000

1

1

\*D3794-1\*

Gasket

\*\*

1 (2P) 12/05/08

## Location

## Loc Qty

## Loc Code

FP

23

82167 ✓

23

FP002

12

75042

4

80435

8

D3794-3

Manufactured No

230

Each

19.0000

1

1

\*D3794-3\*

Gasket

\*\*

1 (2P) 12/05/08

## Location

## Loc Qty

## Loc Code

FP002

19

74530

2

80436

17

83396 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Work Order ID: 83242

\*83242\*

Parent Item: D350-636-013

\*D350-636-013\*

Parent Item Name: Skidtube LH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

Purchased

No

230

Each

745.0000

4

4

\*MS21043-6\*

NUT

\*\*

4 (DP) 12/05/08

## Location

## Loc Qty

## Loc Code

FG

20

103693

20

ST301

725

112314

19

117887

6

118384 ✓

200

120308

500

MS21083C8

Purchased

No

230

Each

148.0000

1

1

\*MS21083C8\*

NUT

\*\*

1 (DP) 12/05/08

## Location

## Loc Qty

## Loc Code

304

100

121185 ✓

50

121349

50

FP002

1

115884

1

ST303

5

115884

0

118077

1

119309

2

119638

2

ST304

42

120731

17

121011

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 83242

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

\*83242\*

\*D350-636-013\*

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

288.0000

1

1

\*NAS1149C0832R\*

WASHER

\*\*

1

2P

12/05/08

Location

Loc Qty

Loc Code

ST297

288

114915 ✓

288

NAS1515H3L

Purchased

No

230

Each

170.0000

4

4

\*NAS1515H3I \*

WASHER

\*\*

4

2P

12/05/08

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

130

118686

3

119438

1

120360

76

121243 ✓

50

NAS1611-005

Purchased

No

230

Each

204.0000

8

8

\*NAS1611-005\*

O-RING

\*\*

8

2P

12/05/08

Location

Loc Qty

Loc Code

FP001

204

106099

31

114220 ✓

105

119438

68

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 83242

\*83242\*

Parent Item: D350-636-013

\*D350-636-013\*

Parent Item Name: Skidtube LH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

219.0000

8

8

\*NAS1611-010\*

O-RING

\*\*

8

2P

12/05/08

Location

Loc Qty

Loc Code

FP

121584✓

10

110915

0

120770

10

FP001

209

110915

14

117460

8

118077

1

118612

3

119438

47

120986

50

121166

36

121259

50

AN8C21A

Purchased

No

260

Each

119.0000

2

2

\*AN8C21A\*

BOLT

\*\*

12/5/10

2P

Location

Loc Qty

Loc Code

ST343

119

118758

3

120094

26

121067

20

121167

20

121275

50

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 83242

**\*83242\***

Parent Item: D350-636-013

**\*D350-636-013\***

Parent Item Name: Skidtube LH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

260

Each

60.0000

1

1

\*\*

**\*D2741\***

Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST

-10

ST466

70

71856

1

76984

19

79516

40

D3672-1

-13

Manufactured No

260

Each

1,016.000

\*\*

**\*D3672-13**

Phenolic Washer

Location

Loc Qty

Loc Code

FP001

34

66821

34

ST060

982

72229

4

76277

478

80369

500

April-16-12 11:06:56 AM

Shop Packet Print

Page 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 15

Work Order ID: 83242

\*83242\*

Parent Item: D350-636-013

\*D350-636-013\*

Parent Item Name: Skidtube LH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

260

Each

148.0000

2

2

\*MS21083C8\*

NUT

\*\*

1121524

88

## Location

## Loc Qty

## Loc Code

304

100

121185

50

121349

50

FP002

1

115884

1

ST303

5

115884

0

118077

1

119309

2

119638

2

ST304

42

120731

17

121011

25

NAS1149D0863J

Purchased

No

260

Each

209.0000

2

2

\*NAS1149D0863.J\*

WASHER

\*\*

1215/10

88

## Location

## Loc Qty

## Loc Code

ST298

209

118078

34

119307

75

~~120308~~

100

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER

NO. 83242 MLJ  
12/04/16

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	RA	PORT HADLOCK, WA	
CHECKED	AB	DRAWING NO.	REV. F
MFG. APPR.	AB	D2750	SHEET 1 OF 11
APPROVED	AB	TITLE	SCALE
DE APPR.	AB	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

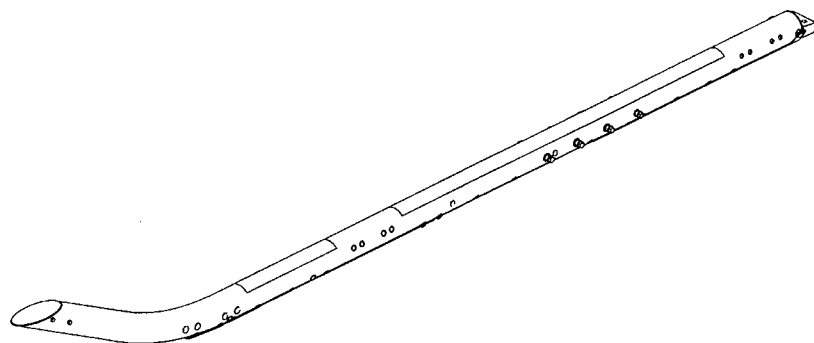
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

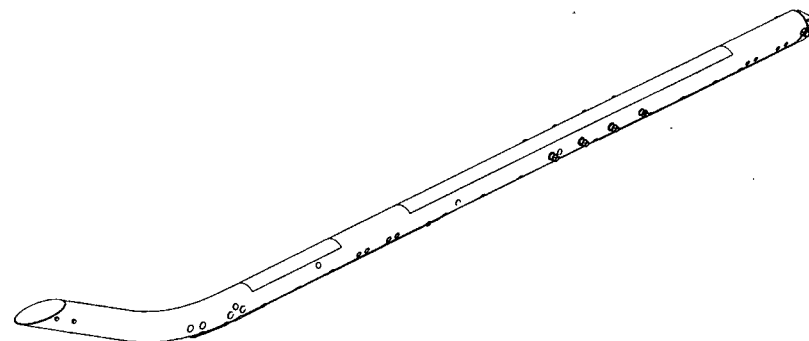
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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CHECKED	A	DRAWING NO.	REV. F
MFG. APPR.	MA	<b>D2750</b>	SHEET 2 OF 11
APPROVED	ME	TITLE	SCALE
DE APPR.	TH	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

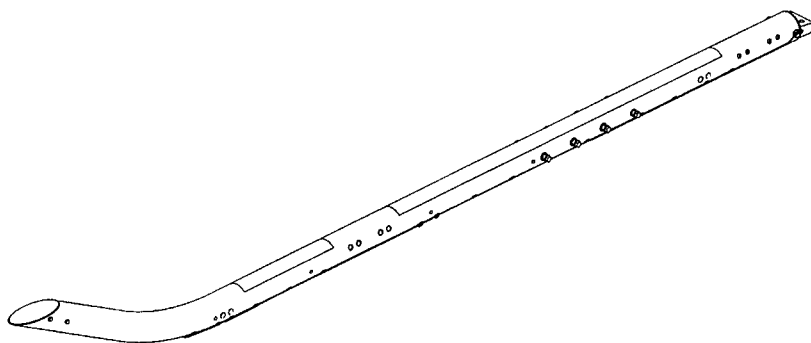
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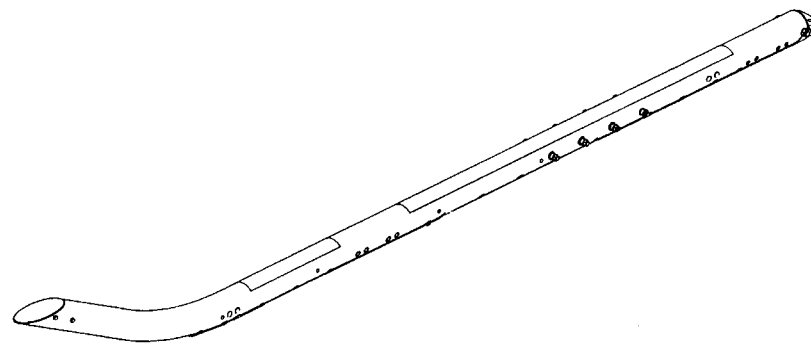
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

83242



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED  
68-09-12/11

DESIGN	PD	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	PD		
CHECKED	NA	DRAWING NO. <b>D2750</b>	REV. F SHEET 3 OF 11
MFG. APPR.	NA	TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS
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DATE	08.07.16		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

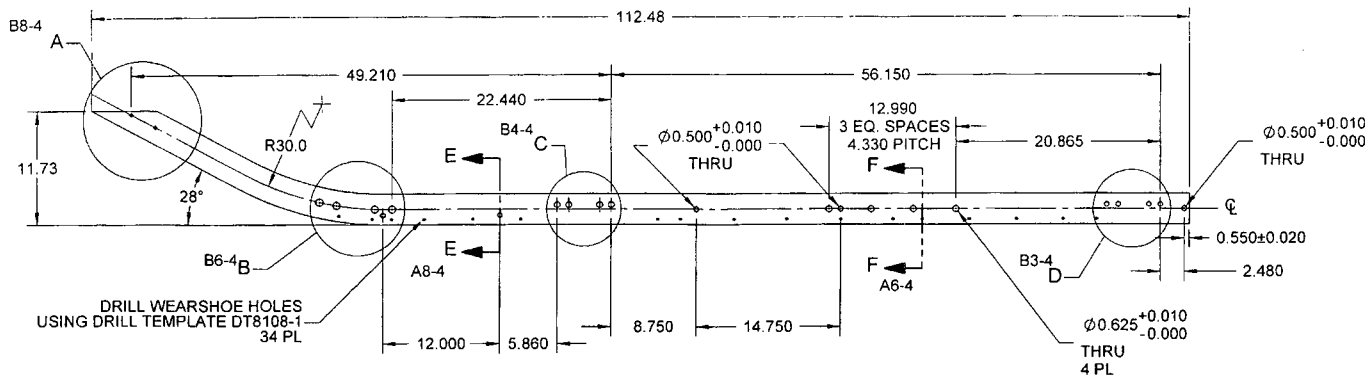
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

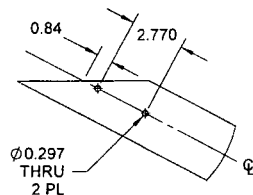
**NOTE:** Date & initial all entries



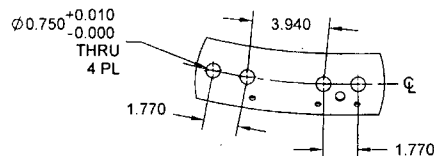
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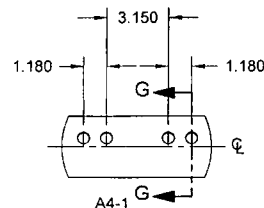
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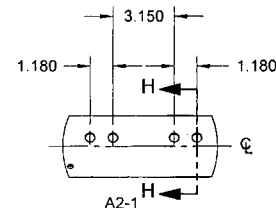
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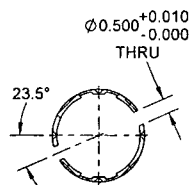
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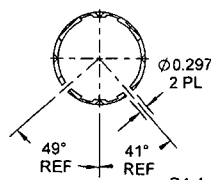
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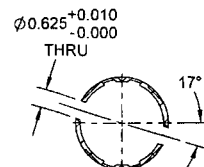
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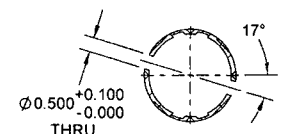
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SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

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CHECKED	1/8	DRAWING NO.	REV. F
MFG. APPR.	1/8	D2750	SHEET 4 OF 11
APPROVED	1/8	TITLE	SCALE
DE APPR.	1/8	350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

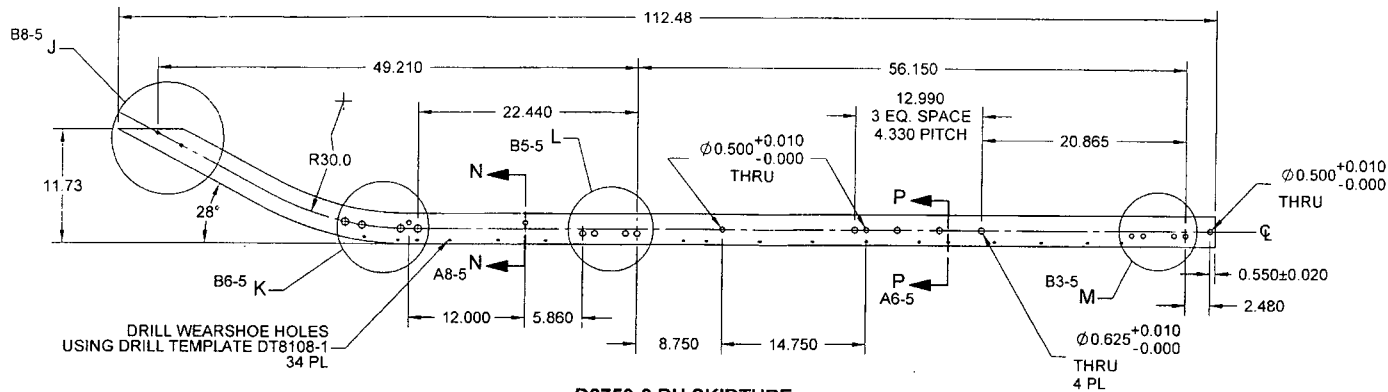
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

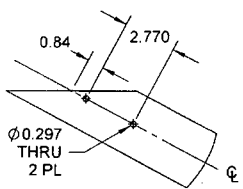
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

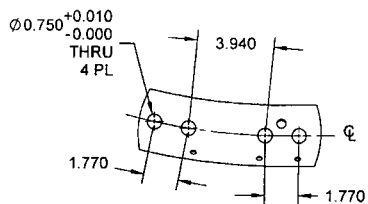
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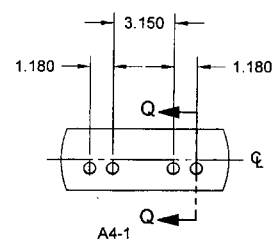
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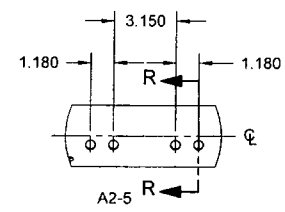
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SCALE 2X



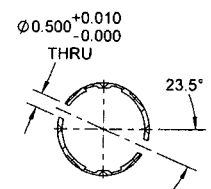
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SCALE 2X



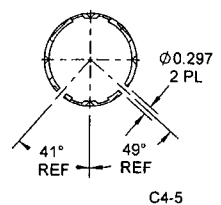
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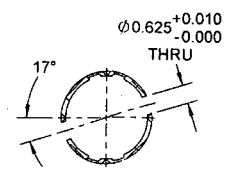
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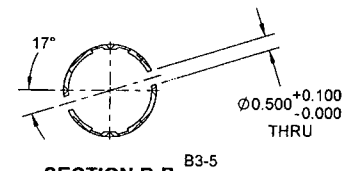
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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DRAWN	PE	PORT HADLOCK, WA	
CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.			SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	<b>08.07.16</b>	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

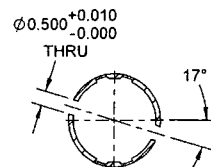
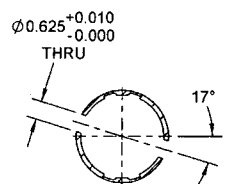
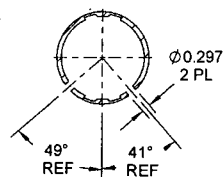
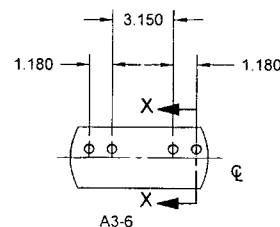
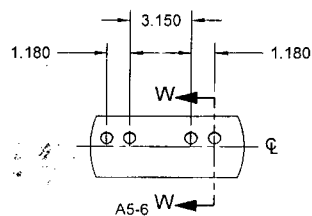
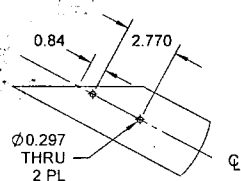
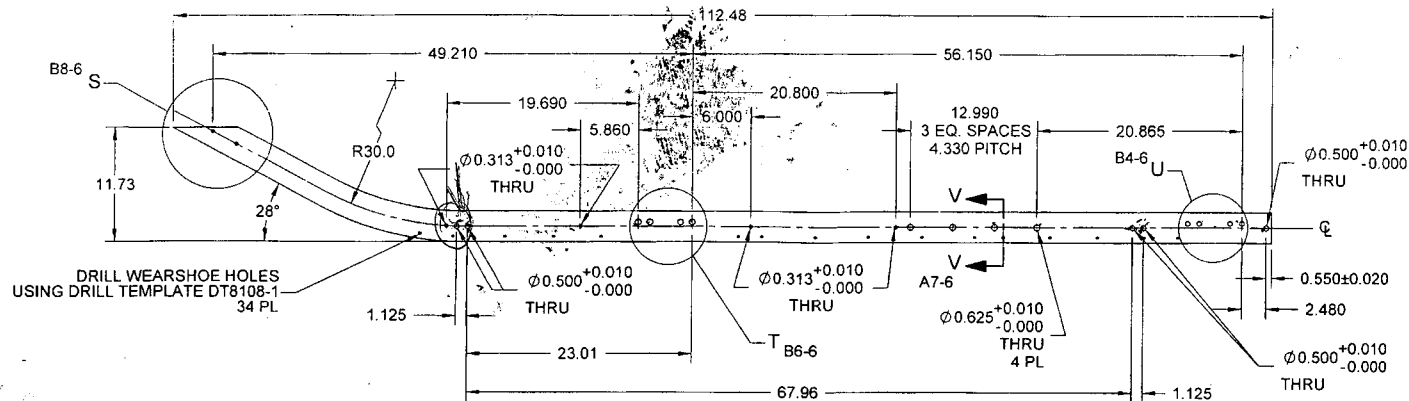
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>
DRAWN	PA	PORT HADLOCK, WA 94025
CHECKED	PA	DRAWING NO. REV. F
MFG. APPR.	PA	<b>D2750</b> SHEET 6 OF 11
APPROVED	PA	TITLE SCALE
DE APPR.	PA	<b>350 SKIDTUBE ASSEMBLY</b> NTS
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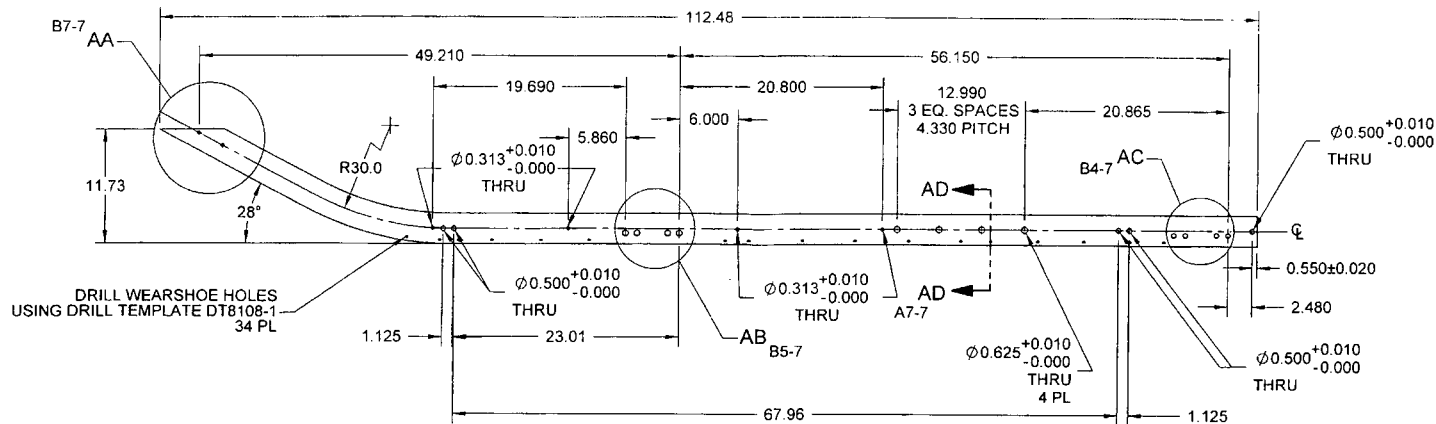
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

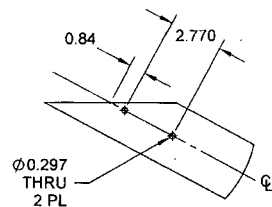
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

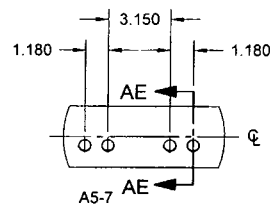
**NOTE:** Date & initial all entries



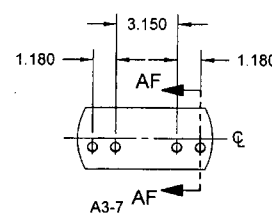
**D2750-4 RH SKIDTUBE**



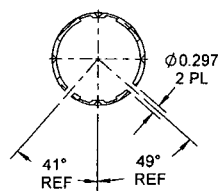
**DETAIL AA**  
D7-7  
SCALE 2X



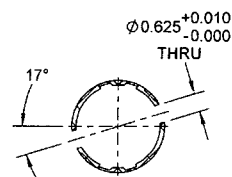
**DETAIL AB**  
C4-7  
SCALE 2X



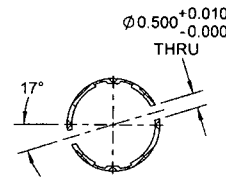
**DETAIL AC**  
D3-7  
SCALE 2X



**SECTION AD-AD**  
D3-7  
SCALE 3X, 17 PL



**SECTION AE-AE**  
B6-7  
SCALE 3X, 4 PL



**SECTION AF-AF**  
B4-7  
SCALE 3X, 4 PL

**RELEASED**

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	<b>08.07.16</b>	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



83242

AN6C44A BOLT  
D2745 BUSHING  
D3631-1 WASHER  
SKIDTUBE, REF  
D3631-1 WASHER  
D2745 BUSHING  
MS21043-6 NUT  
4 PL  
(INSTALL BOLT ON THIS SIDE)

BOND D2739 WEB INTO D2750-1 OUTER TUBE  
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE  
PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.

BLACK ANTI-SKID

A1-8 AG

D2750-1 SKIDTUBE

AFTER FINISH, ALS4-1032-225 INSERT 34 PL

AH

AJ

AK

A7-8

AK

B5-8

2.0 TYP

1.78 TO D2739 WEB

D3488-041 BLADE FITTING

AN8C35A BOLT  
D3793-3 WEARSHOE, REF  
D3794-3 GASKET, REF  
SKIDTUBE, REF  
D3488-041 BLADE FITTING, REF  
D3794-3 GASKET, REF  
D3793-3 WEARSHOE, REF  
AN960C816L WASHER  
MS21083C8 NUT  
(INSTALL BOLT ON THIS SIDE)

D3536-25 GASKET

A4-8

D3535-25 WEARSHOE

D3794-3 GASKET

D3793-3 WEARSHOE

D3537-1 WEARPAD

D3791-1 WEARPLATE

D3794-1 GASKET

D3793-1 WEARSHOE

AN3C5A BOLT  
AN960C10L WASHER  
34 PL

D3537-1 WEARPAD

**D2750-041 350 SKIDTUBE ASSEMBLY, LH**

AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY BOTH ENDS

D3490-3 SPACER

TYP

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D3490-3 SPACER (Ø0.750 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH

C7-8

**SECTION AH-AH**  
SCALE 3X, 4 PL

D2743 SPACER

TYP

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D2743 SPACER (Ø0.625 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO Ø0.484

C6-8

**SECTION AK-AK**  
SCALE 3X, 4 PL

D2744 CAP

1/16" G

AFTER FINISH, INSTALL ALS4-1032-225 INSERT AN3C6A BOLT AN960C10L WASHER NAS1515H3L WASHER 4 PL

D8-8

**DETAIL AG**  
SCALE 2X

**RELEASED**  
04-22-10

AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY BOTH ENDS

D3490-1 SPACER

TYP

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH

C6-8, D5-8

**SECTION AJ-AJ**  
SCALE 3X, 4 PL

D2743 SPACER

TYP

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D2743 SPACER (Ø0.625 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO Ø0.484  
5) SPOT FACE Ø0.750 (BOTH SIDES)

C4-8

**SECTION AL-AL**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. F
MFG. APPR.	AK	D2750	SHEET 8 OF 11
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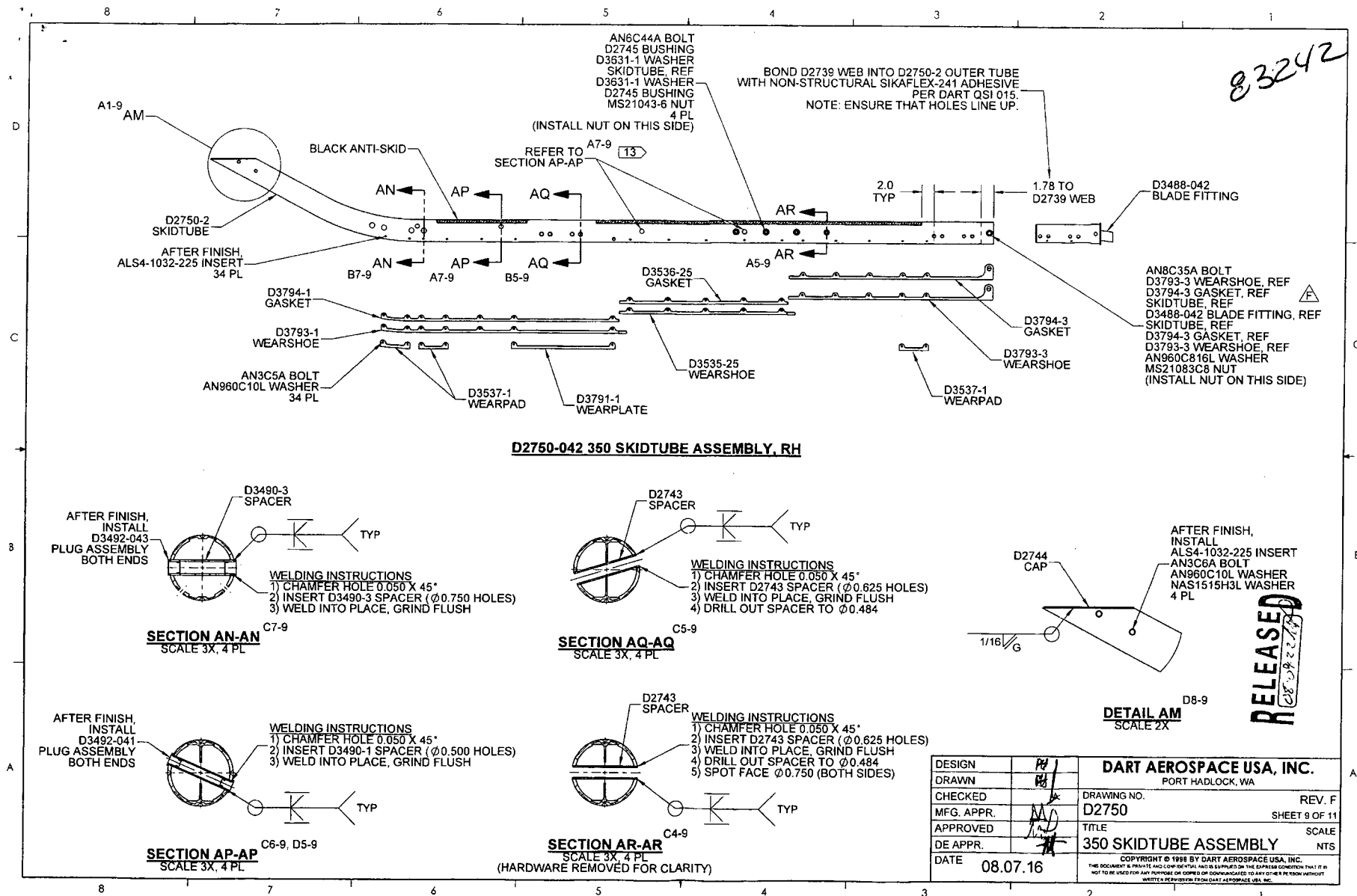
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



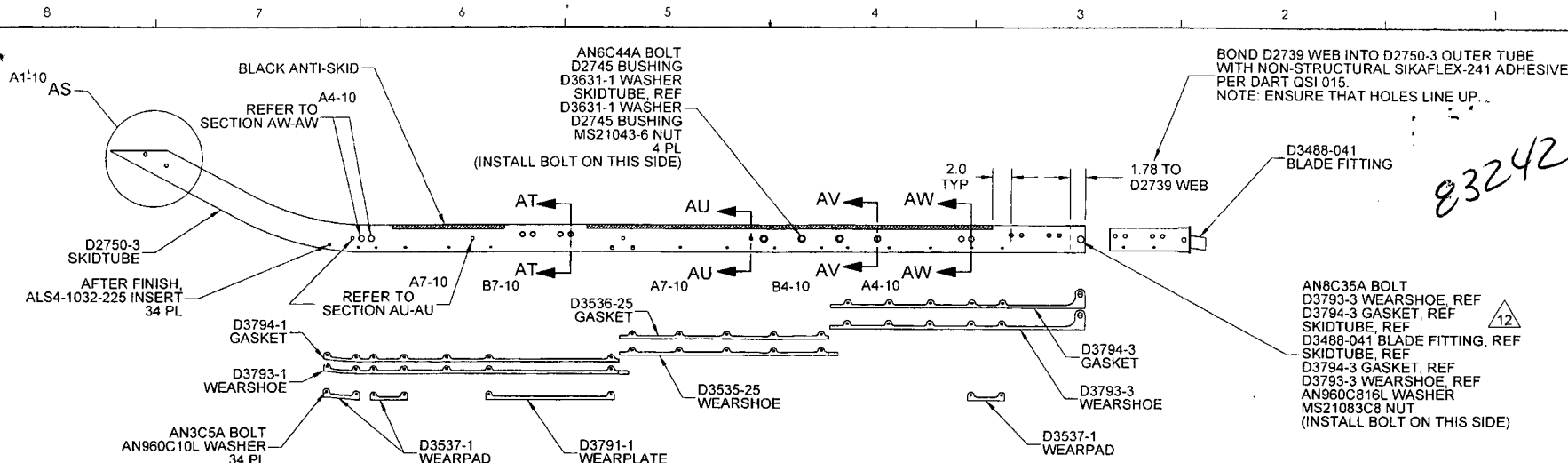
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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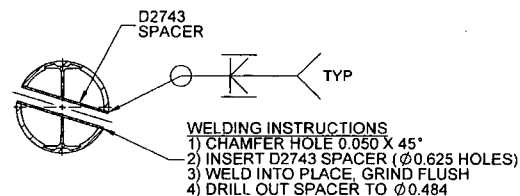
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

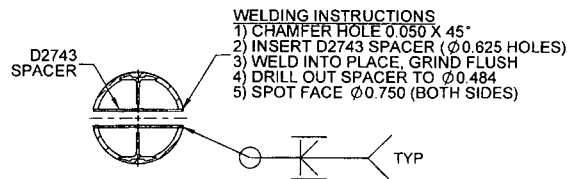
**NOTE:** Date & initial all entries



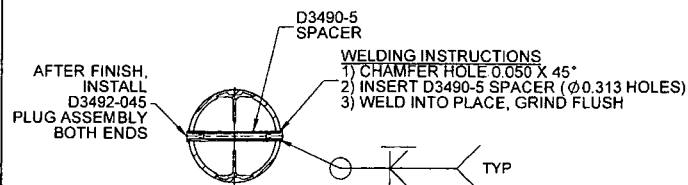
### D2750-043 350 SKIDTUBE ASSEMBLY, LH



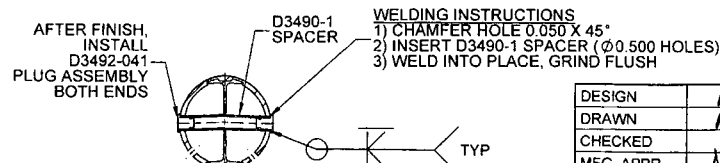
**SECTION AT-AT**  
SCALE 3X, 4 PL



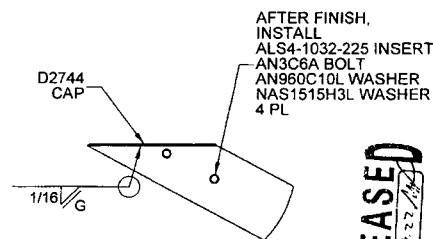
**SECTION AV-AV**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION AU-AU**  
SCALE 3X, 4 PL



**SECTION AW-AW**  
SCALE 3X, 4 PL



**DETAIL AS**  
SCALE 2X

RELEASED  
2015-04-22/10/16

DESIGN	10	DART AEROSPACE USA, INC.	
DRAWN	10	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 10 OF 11
APPROVED		TITLE	SCALE
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

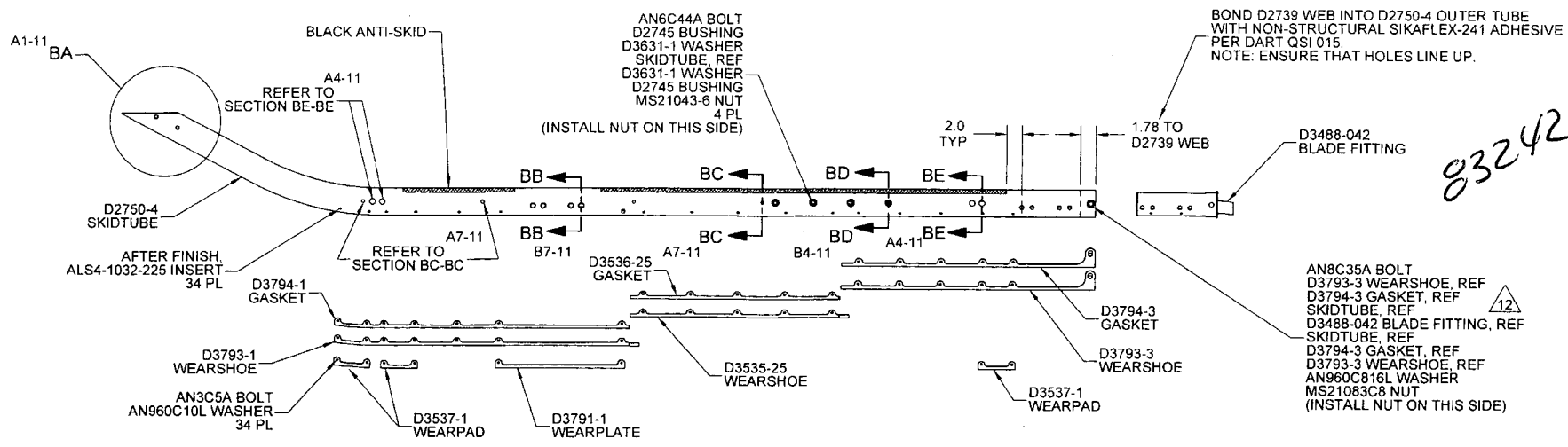
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

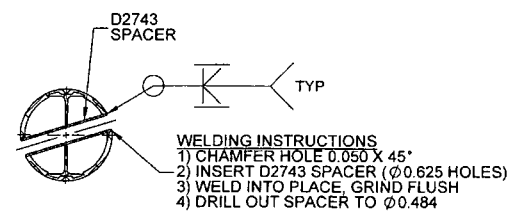
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**NOTE:** Date & initial all entries

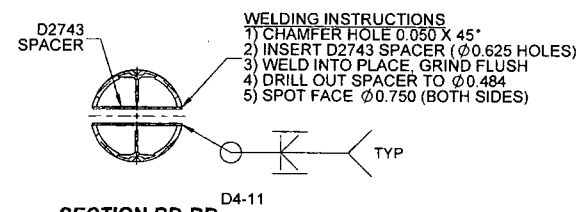
8 7 6 5 4 3 2 1



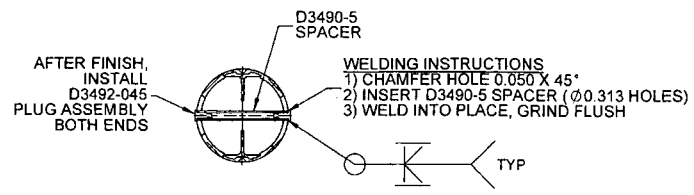
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



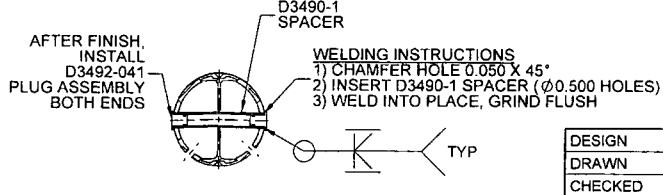
**SECTION BB-BB**  
SCALE 3X, 4 PL



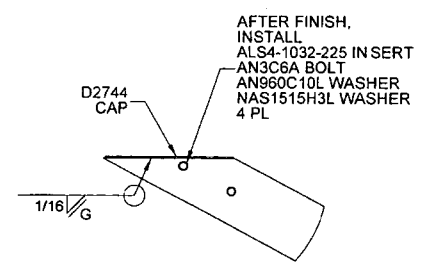
**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL



**DETAIL BA**  
SCALE 2X

DESIGN	HA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	HA	PORT HADLOCK, WA	
CHECKED	HA	DRAWING NO.	REV. F
MFG. APPR.	HA	D2750	SHEET 11 OF 11
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DE APPR.	HA	350 SKIDTUBE ASSEMBLY	NTS
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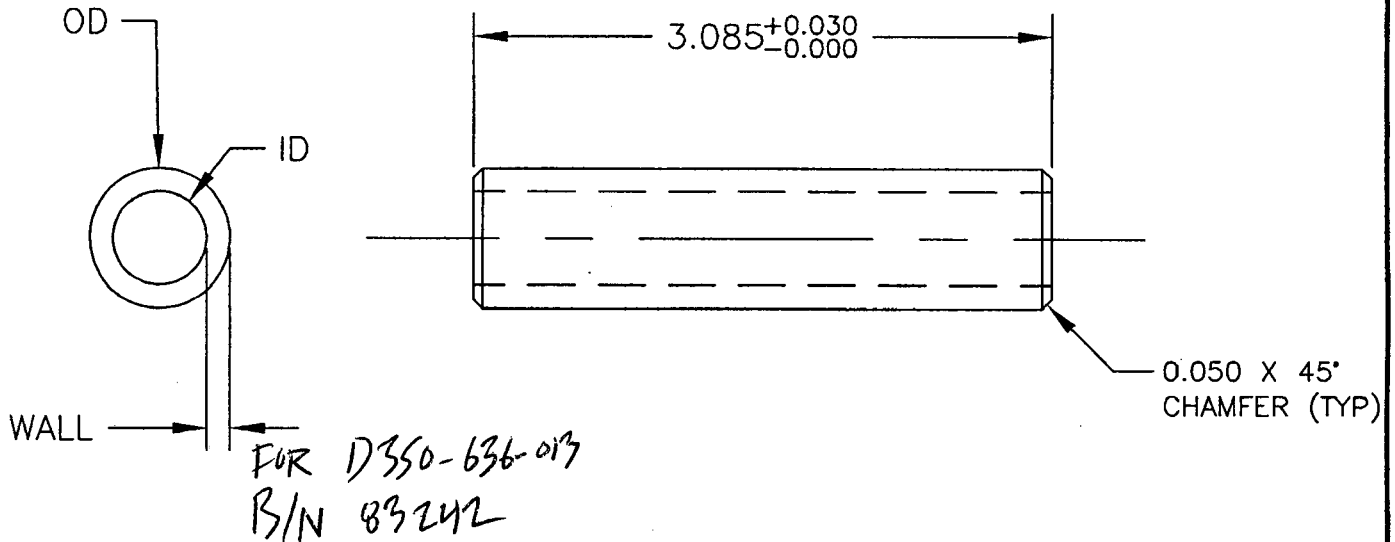
**NOTE:** Date & initial all entries



**DART**

REF

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	

**D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST**

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500 0.630	0.049 0.114	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

**D3490-1/-3/-5 CROSS BOLT SPACER**

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
06-02-07

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NO. 293

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 82796  
Part number: 1350-636-014  
Description: Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier David Reed Date of Test Coupon 12-05-01  
Welder Barclay Elliott Date of Test Coupon 12-05-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

